

Date: Tuesday, 10/06/2008 8:52:01 AM  
User: Julie Lecocq

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET
Job Number	: 39743		
Estimate Number	: 10710		
P.O. Number	:	Part Number	: D32111
This Issue	: 10/06/2008	Drawing Number	: D3211 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A1
Previous Run	: 37931	Material	:
Written By	:	Due Date	: 17/06/2008
Checked & Approved By	: <u>JWD</u> 08.6.10	Qty:	13
Comment	: Est Rev:A New Issue 05-11-17 JLM	Um:	Each
	Est Rev:B Now on Waterjet 06-10-24 JLM		
<b>Additional Product</b>			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
			
Comment: Qty.: 1.4753 sf(s)/Unit Total: 19.1783 sf(s)			
Material: 2024-T3 (QQ-A-250/4) 0.063" thick			
(M2024T3S.063) identify as D3211-1			
Batch: <u>108415 HB 8-8-11</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET			
1-Cut as per Dwg D3211			
Dwg Rev:	<u>A1</u>	<u>HB 8-8-11</u>	
Prog Rev:	<u>A1</u>		
2-Deburr if necessary <u>HB 8-8-11</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<u>HB 8-8-11</u>			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
<u>S 08/08/11 x/13</u>			
Comment: SECOND CHECK			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1			
Deburr <u>Done at step # 2.8</u> <u>6/8/11</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

Job Number: 39743

Part Number: D32111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



PTO

Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 08/09/19

13

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



13X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1

08/09/22

9.0 POWDER COATING POWDER COATING



13X

M 10 S 642

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

9:20  
OF

START TIME:

OVEN TEMPERATURE: 320

FINISH TIME: 9:50

M-1 08/09/24

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-24

X13

11.0 PACKAGING 1 PACKAGING RESOURCE #1



X13

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 211

8/9/24

SCP

12.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-09-19	6.0	Used 3/16 radius die. 1/8 is too sharp a radius.	80	08/09/19	13	108-09-19	108-09-19

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/19	6			TO SK Die 3/16 until Die 1/8	SP 08/09/19			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>39743</b>
<b>Description:</b> Bracket	<b>Part Number:</b>	<b>D3211-1</b>
<b>Inspection Dwg:</b> D3211 <b>Rev:</b> A1		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>RB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	<u>8-8-11</u>	Date:	<u>08/08/11</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	FF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				*			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

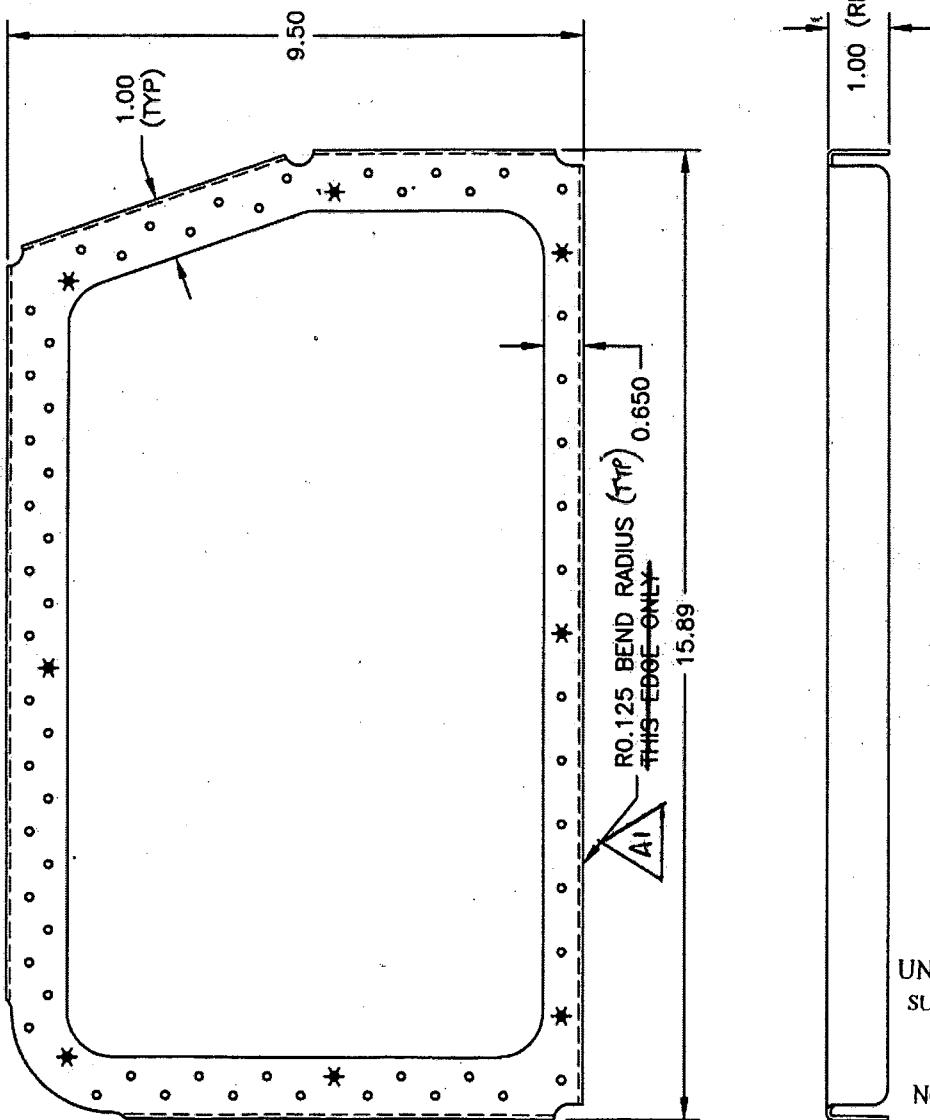
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3211	SHEET 1 OF 2
DATE		TITLE	SCALE
03.09.03		BRACKET	1:3
A	03.09.03	NEW ISSUE	
A1	03.12.05	CHANGE ALL BEND RADII TO R0.125	

**RELEASED**

03.09.03

D3211-1 BRACKET  
 MACHINE PER DRAWING FILE "D3211-A2.DWG"  
 CHECK PER TEMPLATE D3211-1T1  
 MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3  
 USE MINIMUM BEND RADIUS OF  $\phi$ 0.125", EXCEPT WHERE INDICATED  $\phi$ 0.125"   
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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 WITHOUT NOTICE  
 WORK ORDER  
 NO. 39743

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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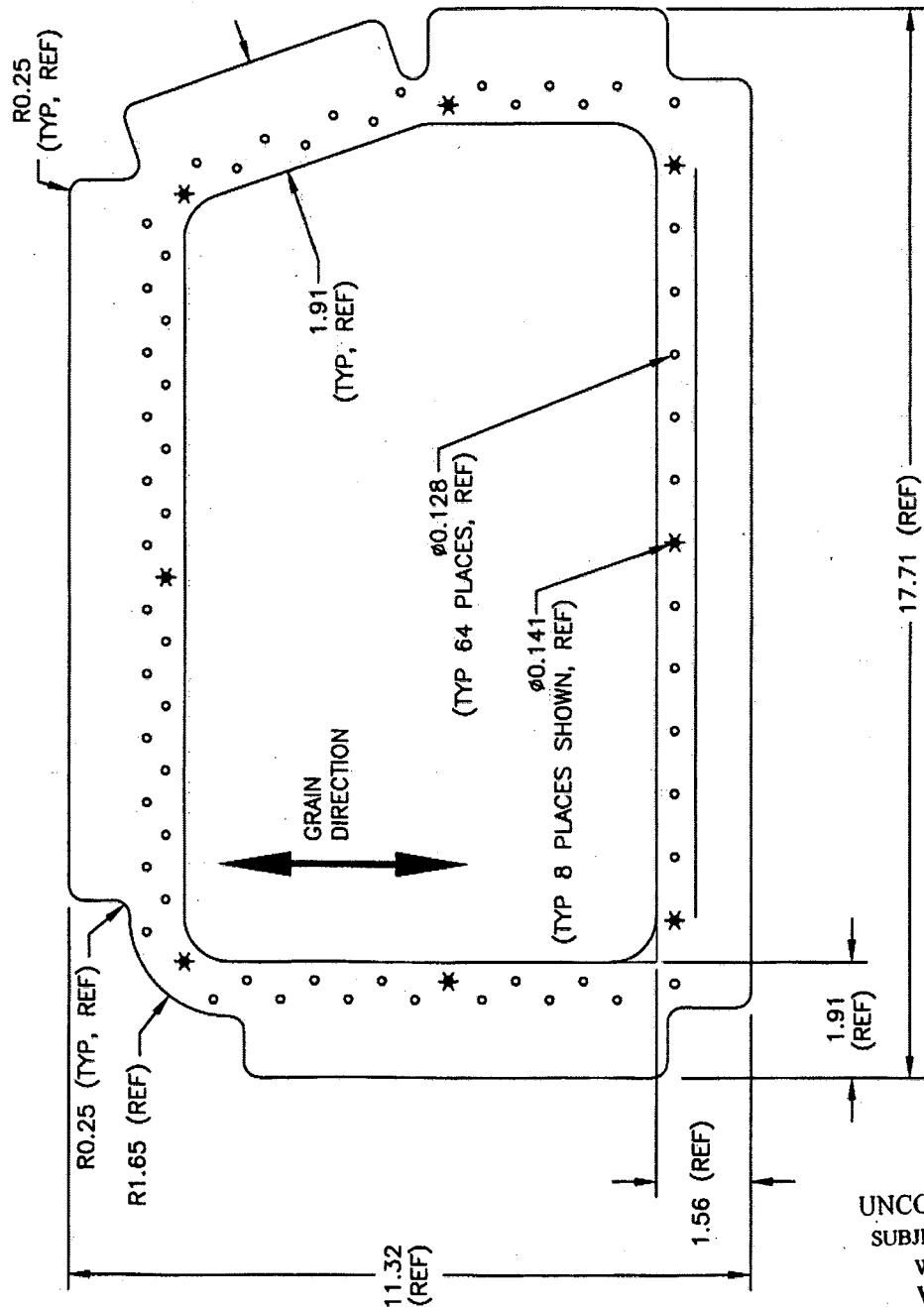
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3211	REV. A	SHEET 2 OF 2
DATE 03.09.03	TITLE BRACKET		SCALE 1:3	

RELEASED  
03-09-15

D3211-1 FLAT PATTERN



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